

WEEK 34

Work Order ID 165533

165533

Page 1

Friday, August 25, 2017 1:49:05 PM

Item ID: D4018-5 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Rib

Start Date: 8/25/2017 Start Qty: 18.00 *18*

Required Date: 8/28/2017 Req'd Qty: 18.00 *18*

Reference: Cust Item ID:

Customer:

Approvals: Process Plan: CM ^{DAS 21 9-89} Date: AUG 25 2017 Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4018	E								
100		0.00							
100									
Large Fab	Memo	1.08							
Large Fab	1- Cut tube as per dwg D4018 2- debur and remove identification markings								
110	QC6- All purchased or subcontracted products	0.00							
110									
QC	Memo	0.00							
Quality Control									
									^{DAS 38 9-89} AUG 31 2017
120	Identify as per dwg & Stock Location: <u>WA04</u>	0.00							
120									
Packaging	Memo	0.18							
Packaging	LOCATION: WA004								
									<u>18A D.M.L. 2017-9-5</u>

18X D.M.L. 2017-8-30

Work Order ID 165533

Friday, August 25, 2017 1:49:05 PM

165533

Page 2

Item ID: D4018-5 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Rib
Start Date: 8/25/2017 Start Qty: 18.00 *18* Cust Item ID:
Required Date: 8/28/2017 Req'd Qty: 18.00 *18* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	1.80							
Quality Control									

DAS
21
9-89

SEP 05 2017

Picklist Print

Friday, August 25, 2017 1:49:05 PM

Page 1

Work Order ID: 165533

165533

Parent Item: D4018-5

D4018-5

Parent Item Name: Rib

Start Date: 8/25/2017

Required Date: 8/28/2017

Start Qty: 18.00

Required Qty: 18.00

Comments: IPP RevA: new issue DD 09.11.26 verified by:EC IPP Rev:B as
per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg
RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD
10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304TS0.500W.049

Purchased

No

100

f

532.3468

0.5558

10.53095

✓ *M304TS0 500W 049*

★★

D.M.L 2017-8-30

Square Tubing

Location

Loc Qty

Loc Code

WA004

532.34684

137257

11

M136011

4.64684

M137257

30.5

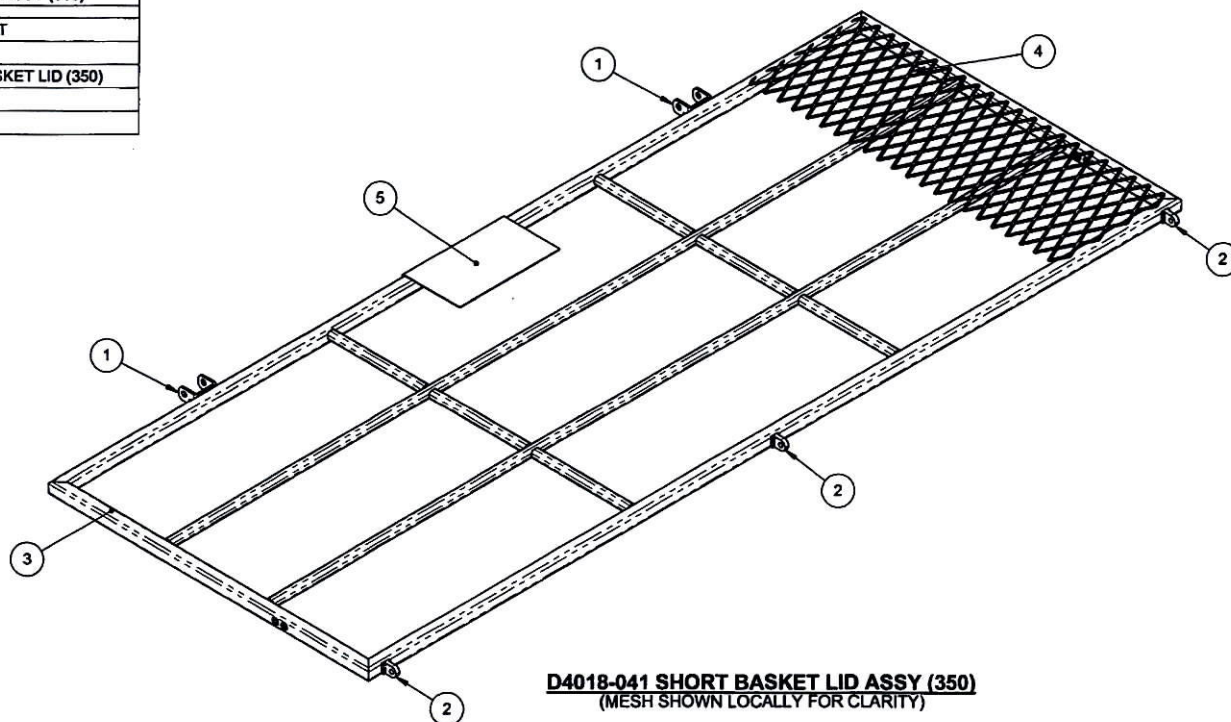
M137992

4.2

M138186

493

ITEM	QTY	P/N	DESCRIPTION
	X	D4018-041	SHORT BASKET LID ASSY (350)
1	2	D2581	MOUNTING BRACKET
2	3	D4016-3	HINGE HALF, LID
3	1	D4018-101	TUBULAR ASSY, BASKET LID (350)
4	1	D4020-7	MESH
5	1	D4021-3	DATA PLATE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 165533
CM

AUG 25 2017

NOTES:

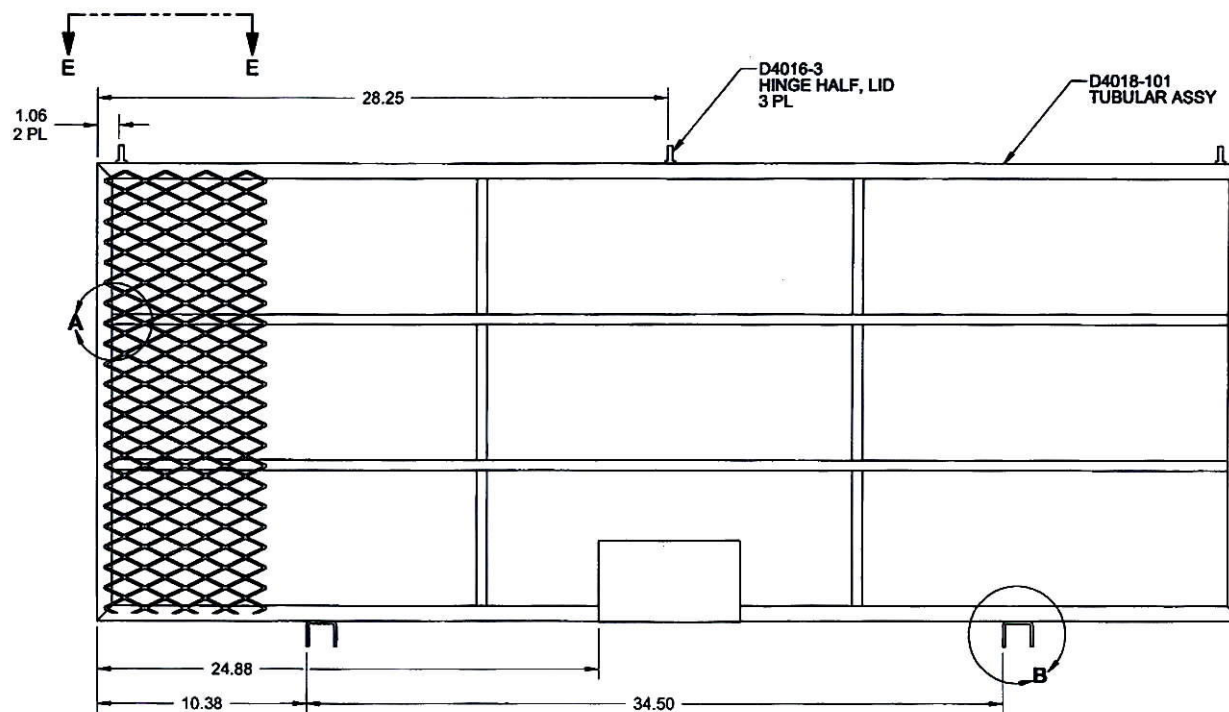
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART P/N AND B/N USING 0.13 (MINIMUM) HIGH LETTERING PER QSI 044 6.4
- 7) WEIGHT: 14.6 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004
- 10) MASK THIS AREA PRIOR TO FINISH

D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

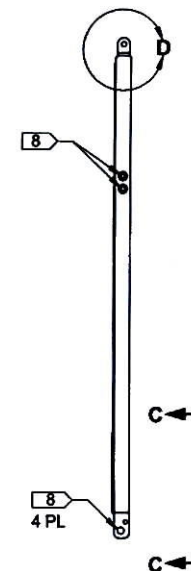
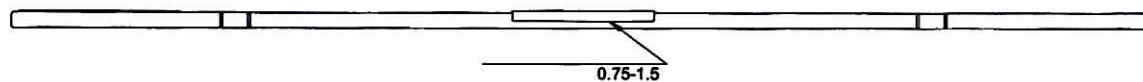
E	ALL DETAIL/SECTION VIEW LETTERS UPDATED. SHEET 1: D2728-3 DELETED, UPDATED NOTE 8, ADDED NOTES 10. SHEET 2 ADDED VIEW E-E. (PAR15-418)	AJS	16.11.24
D	C7-3 D4035-043 WAS D4035-041 (REASON: PROPARM OPTION DELETED)	AJS	13.07.18
C	REMOVED D4086-232, UPDATED DETAIL E ACCORDINGLY (C8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4086- 232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQD. SHEET 2, NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED, WELDING SYMBOLS REVISED. DETAIL VIEW E ADDED (C4-2)&(C82). SIDE VIEWS ADDED (C1-4)&(D1-4).	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4018 REV. E SHEET 1 OF 5 TITLE SHORT BASKET LID ASSY (350) SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	AJS		
CHECKED	JMH		
MFG. APPR.	DD		
APPROVED	WM		
DE APPR.	DS	DATE 16.11.24	

RELEASED
2017-06-07
EN 17-580

APPROVED



D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)



RELEASED
2017-06-07

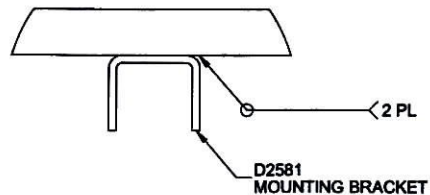
APPROVED

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JMH	DRAWING NO.	REV. E
MFG. APPR.	DD	D4018	SHEET 2 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	SHORT BASKET LID ASSY (350)	NTS
DATE	16.11.24	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

D4020-7
MESH

DETAIL A
SCALE 3X

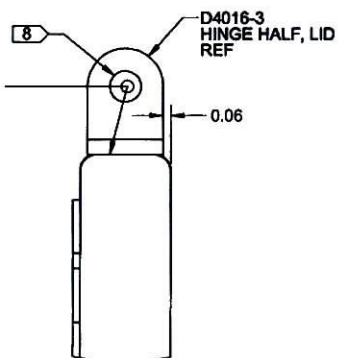


DETAIL B
2 PL
SCALE 3X

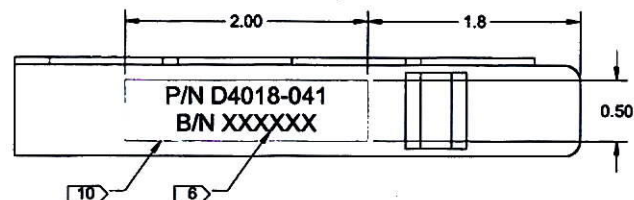
TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

D4021-3
DATA PLATE
REF

VIEW C-C
SCALE 3X



DETAIL D
3 PL
SCALE 3X



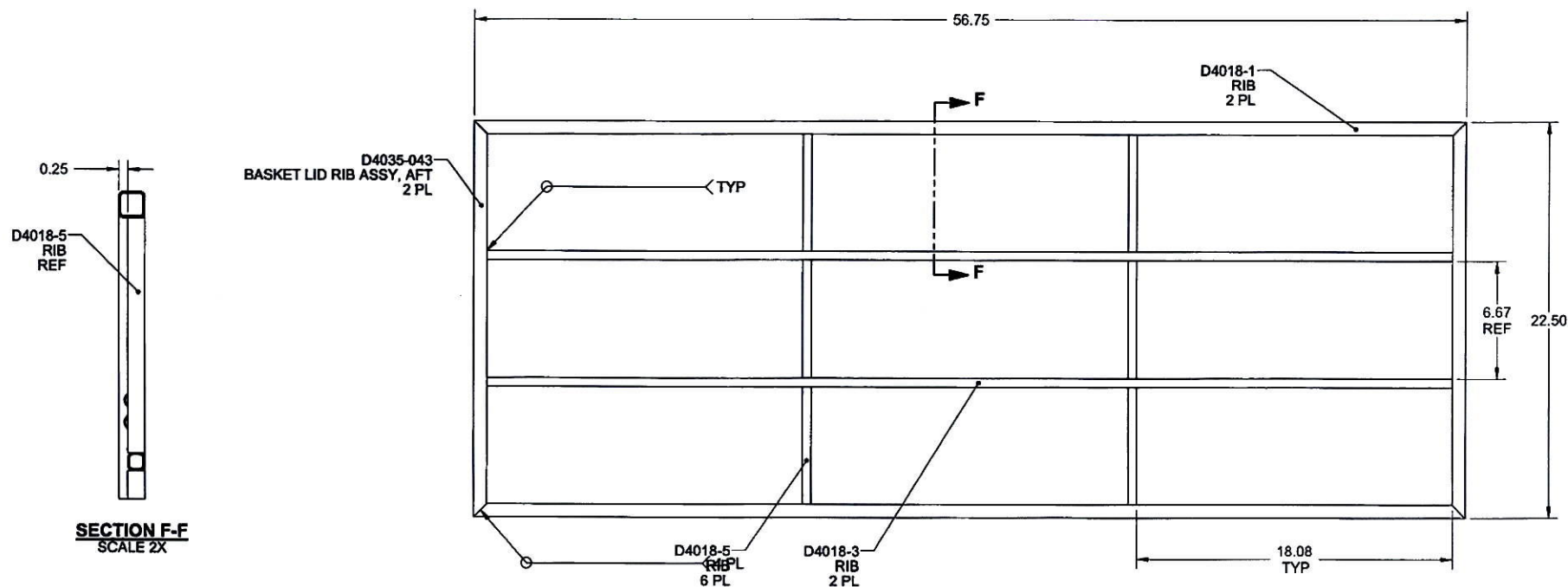
VIEW E-E
SCALE 6X

RELEASED
2017-06-07

APPROVED

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JMH	DRAWING NO.	REV. E
MFG. APPR.	DD	D4018	SHEET 3 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	SHORT BASKET LID ASSY (350)	NTS
DATE	16.11.24	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY -101	P/N	DESCRIPTION
	X	D4018-101	TUBULAR ASSY, BASKET LID (350)
1	2	D4018-1	RIB
2	2	D4018-3	RIB
3	6	D4018-5	RIB
4	2	D4035-043	BASKET LID RIB ASSY, AFT



8 D4018-101 TUBULAR ASSY, BASKET LID (350)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.06 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

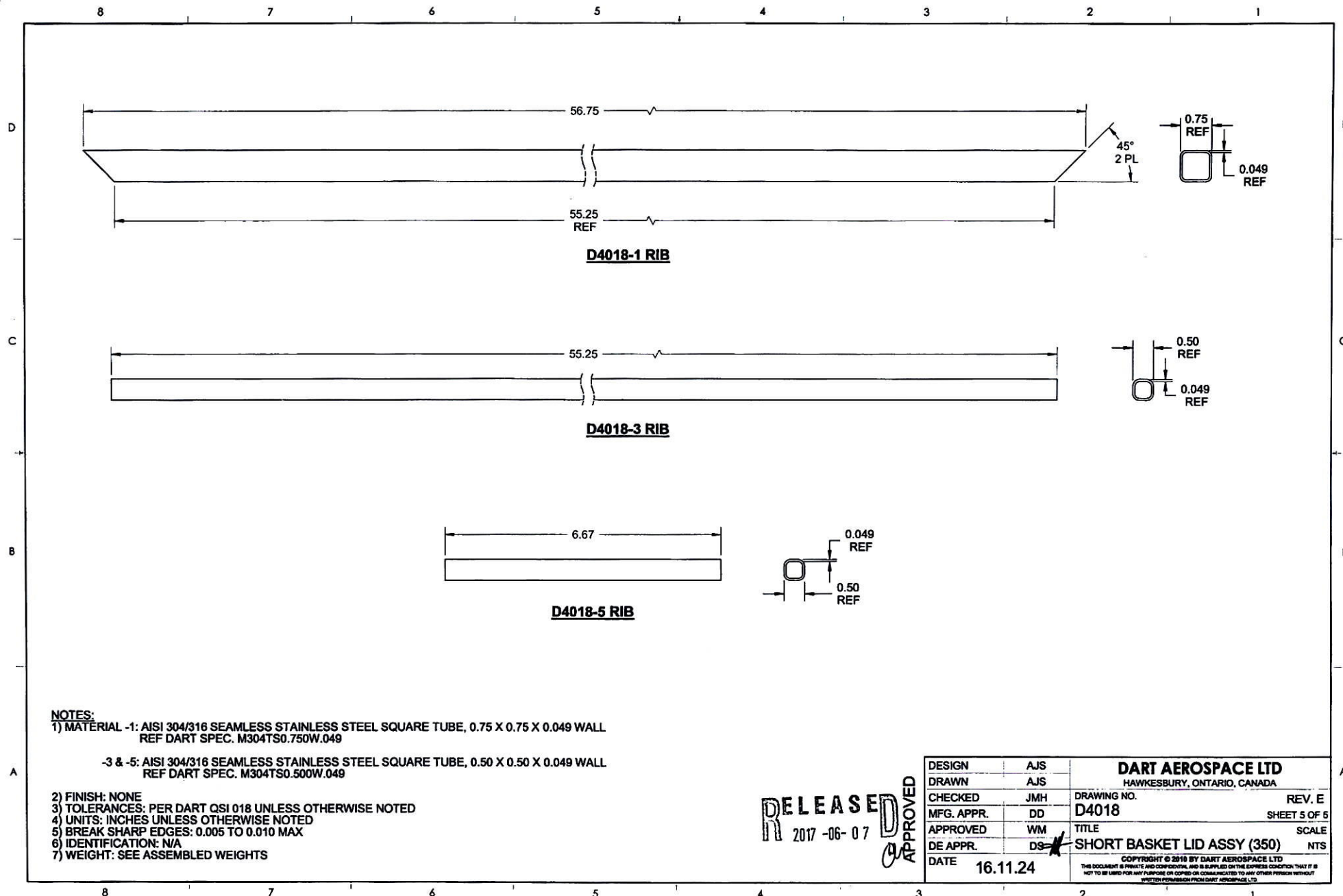
RELEASED
2017-06-07

APPROVED

DESIGN	AJS
DRAWN	AJS
CHECKED	JMH
MFG. APPR.	DD
APPROVED	WM
DE APPR.	DS
DATE	16.11.24

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4018	REV. E
TITLE SHORT BASKET LID ASSY (350)	SCALE NTS
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SHEET 4 OF 5



Friday, April 07, 2017 1:45:14 PM

All amounts are calculated in domestic currency.

All Item ID/GL/WOs All Rec. Employees All Currencies

Grouped by Vendor ID

[illegible]

**EAGLE STAINLESS**

Tube and Fabrication, Inc. 10 Discovery Way Franklin Industrial Park Franklin MA 02038

Tel: 800-528-8650, 508-528-8650 Fax: 800-520-1954, 508-520-1954 Email: eagle@cagletube.com Web: www.cagletube.com

Packing List

Bill Dart Aerospace, Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K8A 1K7
Canada

Ship Dart Aerospace, Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K8A 1K7
Canada

PO Number: PO35151

Shipment No: 129550
Shipment Date: 03/31/17
Order Number: 136891
Order Date: 02/08/17

Customer Code: 000000001912
Phone: (613) 632-5200
Terms: Net 30 Days

Ship Via: **FedXFrCol#94011728**

Quantity				Unit	Description	Job Number
Open	Shipped	Back Ord	Canceled			
2,402	604	1,798		FT	1912-SQ0500048T304 T304 Smle Square Tubing .500" x .500" x .049" Wall x (240) - 117" x .500" / -000 Lengths.) As Drawn Temper. Chem to ASTM A269. Certs Required. Pack to Protect. NOT an Aerospace Application... NOT Defers Material - Chantal Lavole 12/02/15.)	136891-01

POSTED
188801

**EAGLE STAINLESS****Tube and Fabrication, Inc**

Franklin Industrial Park 10 Discovery Way Franklin, MA 02038

Telephone: (508) 528-8650 or (800) 528-8650 Fax: (508) 520-1954 or (800) 520-1954 Website: www.eagletube.com Email: info@eagletube.com

**MATERIAL TEST REPORT
CERTIFICATE OF CONFORMANCE**

Customer:	Dart Aerospace, Ltd.	Date:	3/31/2017
Address:	1270 Aberdeen Street	Purchase Order:	PO35151
		Our Order #:	136891
		Part #:	NA
		Revision:	NA
		Release #:	-

Heat #:	624006		
Source:	50-55504-01-17		
Item:	500 X 500 SQUARE TUBING X .049 WALL T304/304L SMLS		
Specification:	ASTM A269-15a/A213-15c CHEMISTRY ONLY		
Temper:	AS DRAWN TEMPER		
Quantity:	604	Units:	FT

C: .006	Ti: -	Passivation Per ASTM A967:	-
Si: .462	Cb: -	Yield (PSI):	-
Mn: 1.109	Ta: -	Tensile (PSI):	-
P: .030	Fe: balance	Elong. (% IN 2"):	-
S: .004	Cu: .35	Hardness (Rockwell):	-
Ni: 8.94	Al: -	Flattening:	-
Cr: 18.30	N: .032	Flaring:	-
Mo: .314	Co: .149	Rev F/B:	-
Misc Chem:	-	Flange:	-
Misc Chem:	-	Int C/E:	-
Misc Chem:	-	Eddy Current:	-
		Hydrostatic:	-
		Grain Size:	-

Notes: MELT: FRANCE

Notes: MFG: USA

Notes: MERCURY FREE

Comments:

Comments:

Conforms to all drawing and/or specification requirements. To the best of our knowledge the material is mercury free, and compliant with Directive 2011/65/EC and 2006/122/ECOF regarding the Restriction of Hazardous Substances (RoHS), and is conflict free per Dodd-Frank section 1502. Reports governing this material are on file.

Bernie PearsonEAGLE STAINLESS TUBE AND FABRICATION INC.
Bernie Pearson
Quality Assurance Manager

Int.

3/31/2017

Date

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: M304TS 0.500W .049

PO / BATCH NO: PO 35151 / M137257

DATE: 17-04-10

MATERIAL CERT REC'D: yes
 QUANTITY RECEIVED: 60459ft
 QUANTITY INSPECTED: 60459ft
 QUANTITY REJECTED: 0

THICKNESS ORDERED: .049
 THICKNESS RECEIVED: .049
 SHEET SIZE ORDERED: N/A
 SHEET SIZE RECEIVED: N/A

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒ N ☒	
CORRECT FINISH	Y ☒ N ☒	
CORROSION	Y ☒ N ☒	
CORRECT GRAIN DIRECTION	Y ☒ N ☒	
CORRECT MATERIAL	Y ☒ N ☒	
CORRECT THICKNESS	Y ☒ N ☒	
PHOTO REQUIRED	Y ☒ N ☒	
CORRECT MATERIAL	Y ☒ N ☒	ASTM A269
CORRECT REF # TO LINK CERT	Y ☒ N ☒	HT# 624005
CORRECT MATERIAL IDENTIFICATION	Y ☒ N ☒	
CORRECT M# ON THE MATERIAL	Y ☒ N ☒	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☒ N ☒	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☒ N ☒	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW				
TYPE OF MATERIAL	HRC	HRB	DUR A	DUR D
SIZE OF TEST SAMPLE				
HARDNESS / DUROMETER READING				

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>CR</u> DATE: <u>17-04-10</u>	SIGNED OFF BY: _____ DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO35151**

Purchase Order Date 1/31/2017

PO Print Date 1/31/2017

Page Number 1 of 2

Order From :

VU-EAG001

EAGLE STAINLESS
10 DISCOVERY WAY
FRANKLIN, MA
US

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA



FEB 01 2017

Contact Name

Vendor Phone 800 528 8650 Ext.800 520 1954

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

USD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
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1	M304TS0.500W.049 ✓	Square Tubing ✓	3/22/2017 Yes 3/22/2017		600.00 f	\$6.55	\$3,930.00
---	--------------------	-----------------	-------------------------------	--	-------------	--------	------------

MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBING AS PER ASTM A554 MILL FINISH OR ASTM A269 MILL FINISH

Line Total: \$3,930.00

2	M304TS0.500W.049	Square Tubing	6/22/2017 Yes 6/22/2017		600.00 f	\$6.55	\$3,930.00
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MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBING AS PER ASTM A554 MILL FINISH OR ASTM A269 MILL FINISH

Line Total: \$3,930.00

3	M304TS0.500W.049	Square Tubing	9/21/2017 Yes 9/21/2017		600.00 f	\$6.55	\$3,930.00
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MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBING AS PER ASTM A554 MILL FINISH OR ASTM A269 MILL FINISH

PO Instructions: DELIVERY DATE TBD
QUOTE NO 974235

Note:

1/31/2017



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO35151**

Purchase Order Date 1/31/2017

PO Print Date 1/31/2017

Page Number 2 of 2

Order From :
EAGLE STAINLESS
10 DISCOVERY WAY
FRANKLIN, MA
US

VU-EAG001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 800 528 8650 Ext.800 520 1954

Ship To Contact
Ship To Phone
Ship Via:
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency USD
FOB Destination-Collect

Line Total: **\$3,930.00**

4	M304TS0.500W.049	Square Tubing	12/21/2017	600.00	\$6.55	\$3,930.00
			Yes	f		
			12/21/2017			

MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBING AS PER ASTM A554 MILL FINISH OR ASTM A269 MILL FINISH

Line Total: **\$3,930.00**

5	71401-45	PROCUREMENT QUALITY CLAUSES	12/21/2017	1.00	\$0.00	\$0.00
			No			
			12/21/2017			

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)
A026 certification of material conformance
A041 quality management system
A042 dart notification by supplier
A043 retention of quality document

SP17-4-7

Line Total: **\$0.00**

PO Total: **\$15,720.00**

PO Instructions: DELIVERY DATE TBD
QUOTE NO 974235

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1 **Change Date:** 1/31/2017